

Work Order ID 160293***160293***

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Tuesday, April 25, 2017 12:52:05 PM

Item ID: D4149-041MB

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Crosstube Lug Assembly, Matte Black

Start Date: 5/8/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/10/2017 Req'd Qty: 2.00

2

Customer:

Reference: REPAINT LUGS M BLACK

Approvals: Process Plan:

Date: APR 25 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4149

C



100

0.00

100

Small Fab

Memo

0.48

PICK FROM STOCK
D4149-041 X2

B: 155794

DISASSEMBLE LUGS TO BE REPAINTED MAT BLACK

REPLACE HARDWARE AS NEEDED

2DAS
41
9-89

MAY 31 2017

105

0.00

105

SprayPaint

Memo

0.00

SCUFF & REPAINT

Prime per QSI 005 4.2.1

Batch: 136772

Paint Matte Black as per QSI005 4.2.2

Batch: 135519

2DAS
41
9-89

MAY 31 2017

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NS1

NS2

?

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Reference: REPAINT LUGS M.BLACK

NR1

NR2

[illegible]

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160293

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Item ID: D4149-041MB**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Aft Crosstube Lug Assembly, Matte Black**Start Date:** 5/8/2017 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 5/10/2017 **Req'd Qty:** 2.00***2*****Customer:****Reference:** REPAINT LUGS M.BLACK**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <i>ST</i>	0.00							
120						<i>2</i>		<i>DAS</i>	
Packaging	Memo	0.02						<i>6</i>	
Packaging								<i>9-89</i>	<i>JUN 01 2017</i>
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.20							<i>17/6/1</i>
Quality Control									<i>ST</i>

DAS
21
*9-89**JUN 01 2017*

Picklist Print

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Work Order ID: 160293

160293

Parent Item: D4149-041MB

D4149-041MB

Parent Item Name: Aft Crosstube Lug Assembly, Matte Black

Start Date: 5/8/2017

Required Date: 5/10/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4149-041		Manufactured	No				Each	7.0000		2			
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D4149-041

**

Aft Crosstube Lug Assembly

Location

Loc Qty

Loc Code

ST539

1

155794

1

ST539A

6

158127

2

159056

4

25M

APR 25 2017

-AN4C13A 2x

-AN3C12A 4x

-MS21043-3 4x

MS21043-4 2x

NAS1149CO432R 4x

VAS1149CO332R 8x

M134754

M133990

M136182

132803

134676

136444

68-6
9E
SVD
68-6
9E
SVD
68-6
9E
SVD
68-6
9E
SVD
68-6
9E
SVD
68-6
9E
SVD

DAS
36
9-89

DQA: _____ Date: _____

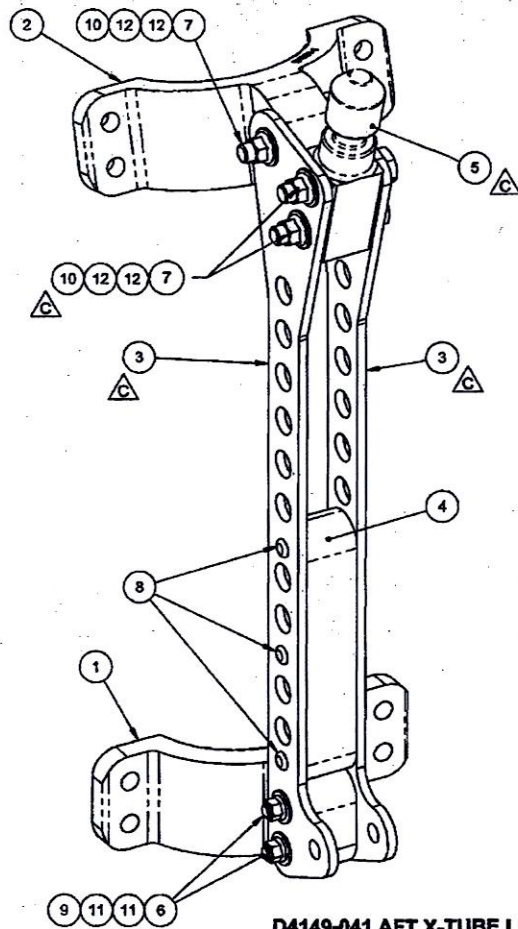


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					



D4149-041 AFT X-TUBE LUG ASSY

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20815-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

RELEASED
 2011-02-20
 JN

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20815-4M18 WAS MS20815-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3905-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20815-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3) REASON: SEE TR-D350-807-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED BY THE EXPRESS AGREEMENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COPIED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	